

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009757**Date Inspected:** 26-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** Deck Panels**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

North Lay Down

QA inspector performed conventional Ultrasonic (UT) Inspection on deck panel tack weld areas. The inspection is preliminary prior to using the phased array (PAUT) testing system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP458-001, 5 ribs, 10 welds, 190 total tack welds inspected.

Weld 1 scanned 19 locations with 1 indications.

Weld 2 scanned 19 locations with 2 indications.

Weld 3 scanned 19 locations with 3 indications.

Weld 4 scanned 19 locations with 2 indications.

Weld 5 scanned 19 locations with 5 indications.

Weld 6 scanned 19 locations with 2 indications.

Weld 7 scanned 19 locations with 3 indications.

Weld 8 scanned 19 locations with 2 indications.

Weld 9 scanned 19 locations with 1 indication.

Weld 10 scanned 19 locations with 0 indications.

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QA Inspector performed initial Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled “Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds, # UT 04-0120F4 PJP Rib Weld” after conventional UT was performed on tack welded areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows:

DP458-001: 7 tack weld location found compliant and 14 tack weld locations found non-compliant.

QA Inspector performed Phased Array Ultrasonic Testing (PAUT) following the guide lines of UT procedure titled “Phased Array Ultrasonic Testing for the Detection and Sizing of Suspected Planar Discontinuities (Cracks) in PJP Welds, # UT 04-0120F4 PJP Rib Weld” after ZPMC welding personnel performed weld repairs of tacked areas of the Partial Joint Penetration (PJP) welds joining u-ribs to deck plate. The deck panels examined are as follows:

DP400-001: 1 tack weld locations found compliant and 0 tack weld locations found non-compliant.

DP431-001: 3 tack weld locations found compliant and 1 tack weld locations found non-compliant.

DP485-001: 5 tack weld locations found compliant and 2 tack weld locations found non-compliant.

DP350-001: 1 tack weld locations found compliant and 0 tack weld locations found non-compliant.

Tack weld locations found non-compliant are marked on U-rib and deck plate for ZPMC’s reference for repair. See Caltrans U-rib to Deck Panel- Tack Weld Assessment sheets dated 26th October, 2009 for further information on PAUT inspections.

Bay 9

This QA Inspector performed Ultrasonic Testing (UT) on OBG components identified as OBG U-RIBS previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date.

DP 3002-001-058, 059, 068, 069

DP 3040-001-090, 091, 100, 101

Milling Position

This QA Inspector performed Ultrasonic Testing (UT) on TOWER components identified as BACKFILL PLATE previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 The QA Inspector observed no rejectable indications at the time of testing. The QA Inspector generated a TL-6027 UT report on this date.

AE Corner Backfill ESTL3-4G/k-38

DE Corner Backfill ESTL3-4G/k-25

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
